

Blue

Date: Wednesday, 03/09/2008 10:25:56 AM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number : 41717	
Estimate Number : 10834	
P.O. Number :	Part Number : D29332
This Issue : 03/09/2008 S.O. No. :	Drawing Number : D2933 REV C - BLUE
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 41129	Material :
Written By :	Due Date : 26/09/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JUL 08.9.03</u>	
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev: C As per Rev C 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Issue material from stock: 7075-T7351 QQ-A-250/12
Cut Size 2.0 x 6.25 X 6.00
Grain Along Long 6.00 Length
Batch No: B 34872

ml 08/09/09

(4)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
1-Inspect part number and batch number are programmed correctly.
2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
5-Deburr

ml 08/09/09

(4)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet

ml 08/09/09

(4)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

ml 08/09/09

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:25:56 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 41717

Part Number: D29332

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



DTP 08/09/10 (4)



Comment: SECOND CHECK

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(4X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-1 08/09/10

7.0 SPRAY PAINTING SPRAY PAINTING



Comment:

-PRIME

-SPRAY PAINT DELFLEET BLUE

-CLEAR DELFLEET

B126729
B105918
B105917

> ml 08 09 25

(4)

(P70)

8.0 QC14 INSPECT SPRAY PAINT



08-09-25

Comment: INSPECT SPRAY PAINT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



(4X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 445

8/9/25

SP

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/09/26

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2933-2 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 08/09/02
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>41717</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08-09-24</u>	<u>7.0</u>	Primer is slightly visible on all the edges, and corners of the saddles. R.C. Primer is slightly lighter than the base in color.	<u>BS1412</u>	scuff & repaint per Q51005, Next order grey primer will be used.	<u>BS1412</u> <u>08-09-24</u>	<u>08-09-25</u>	<u>BS1412</u>	<u>08-09-24</u>

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 41717
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

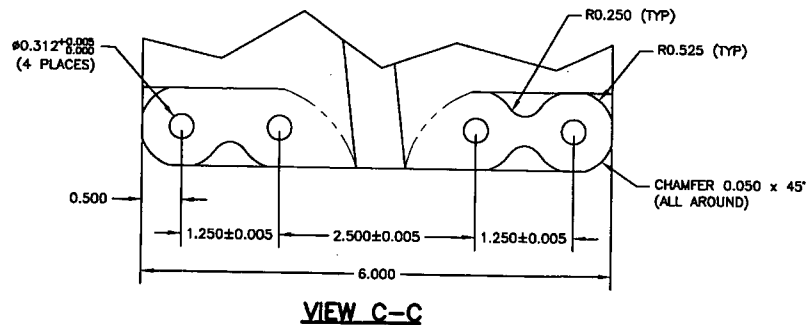
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.126	.128	.128	.127		
B	0.100	0.140		.126	.127	.125	.125		
C	0.100	0.140		.128	.121	.121	.125		
D	0.210	0.230		.223	.222	.222	.222		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.506	2.506	2.506	2.506		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.574	1.577	1.576	1.576		
J	2.495	2.505		2.506	2.499	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.111	.110	.111	.110		
O	0.540	0.560		.550	.552	.550	.550		
P	0.490	0.510		.504	.503	.504	.502		
Q	3.715	3.725		3.719	3.718	3.716	3.716		
R	2.470	2.510		2.492	2.491	2.490	2.490		
S	0.240	0.270		.254	.254	.255	.254		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.627	1.630	1.629	1.629		
V	1.362	1.372		1.366	1.365	1.366	1.368		
W	0.316	0.321		.320	.317	.320	.320		
X	1.125	1.145		1.137	1.136	1.137	1.136		
Y	1.565	1.585	DT8695 A/B	1.577	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>ML</i>
Date: 08/09/09

Audited by: <i>DTP</i>
Date: 08/09/10

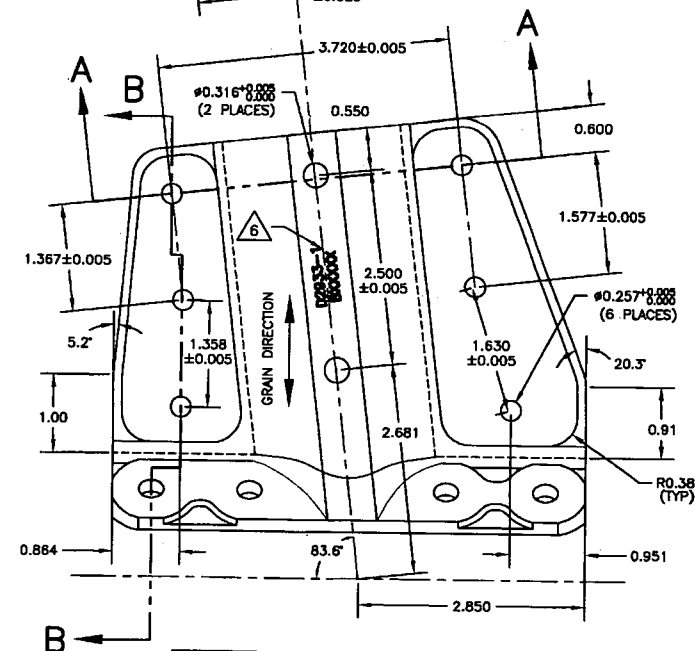
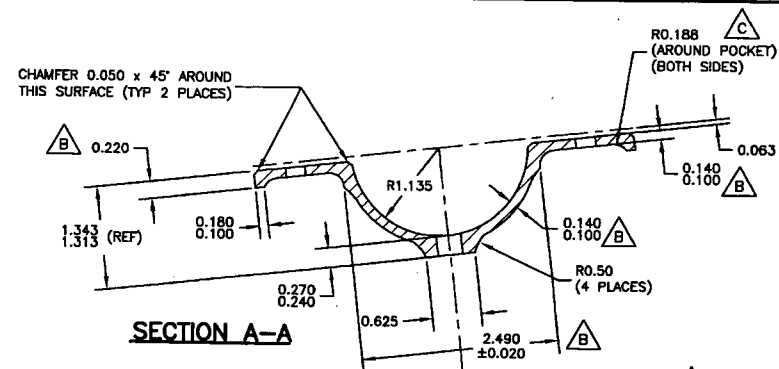
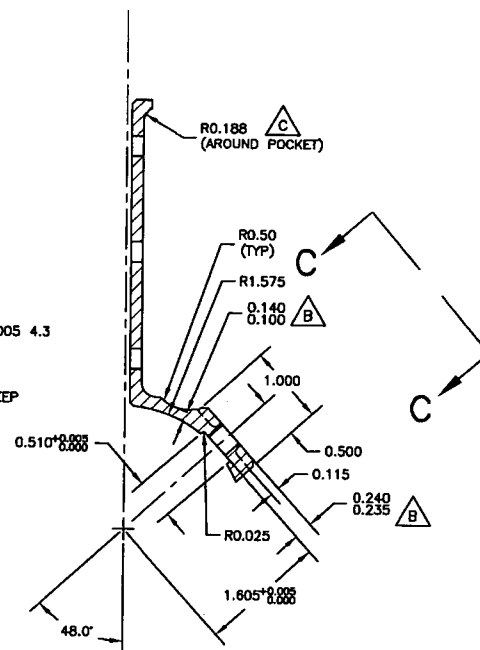
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	
DART AEROSPACE USA, INC.		REV. C
DRAWING NO. D2933		SHEET 1 OF 1
TITLE SADDLE INSIDE		SCALE 2:3

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